

Date: Friday, 06/02/2009 10:39:39 AM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D206-540-013
Job Number : 45589	
Estimate Number : 10804	
P.O. Number :	Part Number : REWORK15
This Issue : 06/02/2009 S.O. No. :	Drawing Number : REWORK
Prsht Rev. : NC	Project Number :
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision :
Previous Run : 00015	Material :
Written By :	Due Date : 13/02/2009 Qty: 1 Um: Each
Checked & Approved By :	
Comment :	

PROTOTYPEPLEASE RETURN ALL ISSUED
DATA TO ENGINEERING

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1
 PULL FROM HAI:

1 X D206-540-013 B44222

CUT/REMOVE HINGES
 REMOVE HINGE PLATES D2232-1 & D2232-3
 (DISCARD)

INSTALL/WELD NEW HINGES
 D3748-1 B
 D3749-1 B
 PER DRWG

PLC 09-02-10

2.0	D37481	Hinge Half
-----	--------	------------



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)
 Hinge Half

B45605 → 2*
B38225 → 1

PLC 09-02-10

3.0	D37491	Hinge Half
-----	--------	------------



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)
 Hinge Half

338826

PLC 09-02-10

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------

**Comment:** INSPECT WORK TO CURRENT STEPQC9 - PD 09-02-10
QC5 - S 09/02/10
ALC
40 + Base 15

Date: Friday, 06/02/2009 10:39:39 AM
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Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206-540-013

Job Number: 45589

Part Number: REWORK15

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

POWDER COATING

POWDER COATING



M109996



Comment: POWDER COATING

15:15

400°

TOUCH UP OR REPAINT A/R

15:45

BR 09-02-10

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

RETURN TO DAN STOW FOR HAI

Boano

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/11

Job Completion



U 09.02.11

PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D206-540-013

Job #: _____

Date: 09.02.06

Product Name: HELI-UTILITY-BASKET

Requested By: MB (HAI)

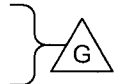
Design Manager Approval: 

Quantity	Part Number	Category	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
1	D206-540-013	WELD + PAINT	HELI-UTILITY-BASKET	09.02.05	N/A	ASAP	MODIFY EXISTING BASKET FOR HAI.	
							TRUCK LEAVES ON 09.02.11	

44222

00569

ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
1	X		D2330-041	BASKET ASSEMBLY
3		X	D2330-043	LID ASSEMBLY
7	1		D2012-107	CLEVIS
8	4		D2235-1	RIB
9	2		D2253-1	LUG
10	2		D2254	GUSSET
11		1	D2327-1	BUSHING
12	1		D2327-3	BUSHING
13		1	D2329	LABEL PLATE
14	2		D2330-1	FRAME
15	2	2	D2330-3	FRAME
16	1		D2330-5	FRAME
17	1		D2330-7	FRAME
18	1	2	D2330-9	FRAME
19		2	D2330-11	FRAME
20		2	D2330-13	FRAME
21		1	D2330-15	FRAME
22	4	2	D2581	MOUNTING CHANNEL
23	3		D3748-1	HINGE HALF
24		3	D3749-1	HINGE HALF



NOTES:

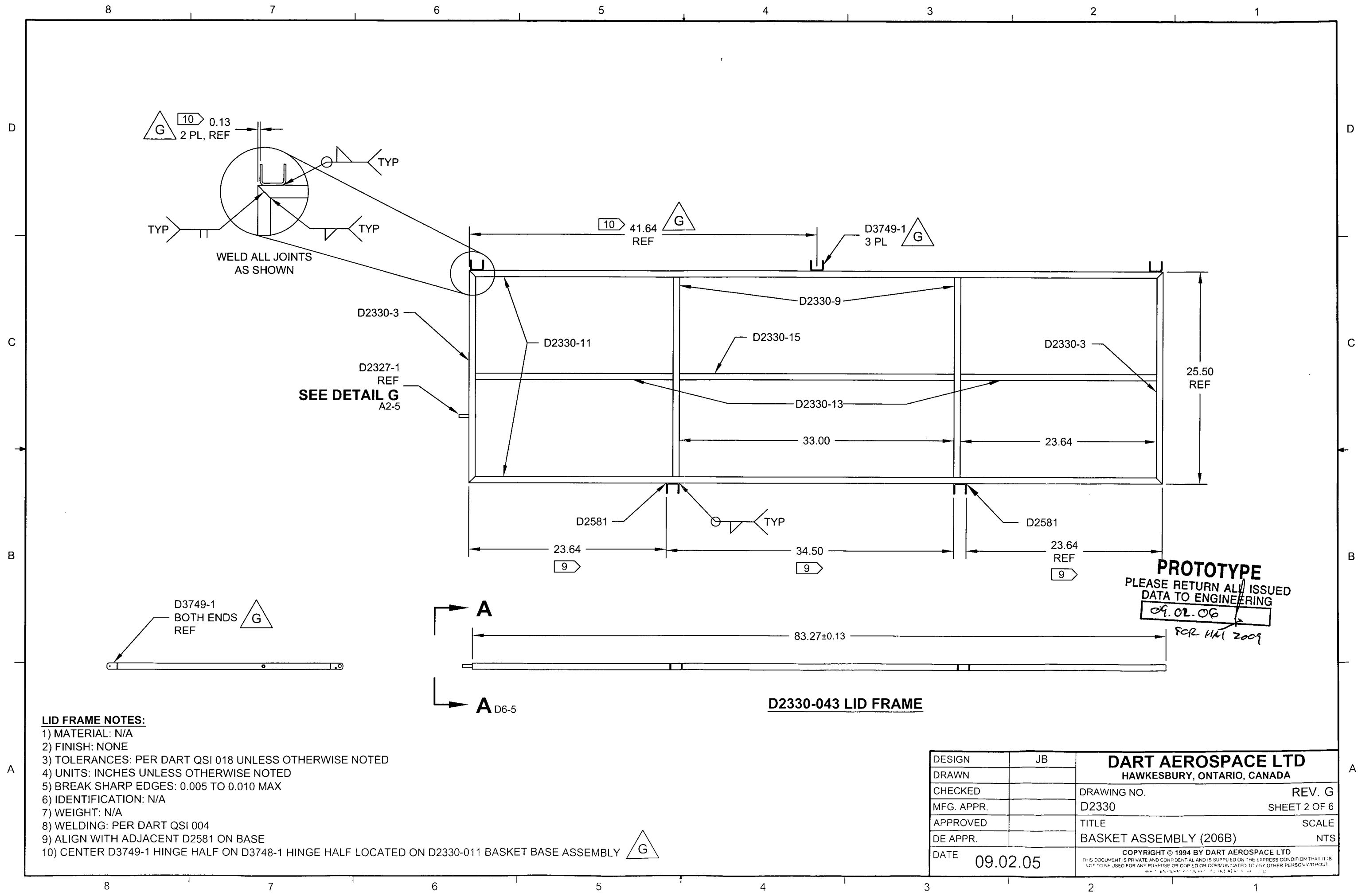
- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: N/A
- 9) WELDING: PER DART QSI 004

PROTOTYPE
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09.02.06

PCR HAI 2009

G	ADDED 'ITEM' COLUMN TO PARTS LIST; ADDED NOTE 10 ON SHT 2; ITEMS 23 AND 24 REPLACE D2232-1 AND D2232-3; REORGANIZED VIEWS/SECTIONS/DETAILS. REASON: SEE PAR#09-006.	MB	09.02.05
F	DRAWING UPDATED TO CURRENT STANDARDS. SHEET 6 ADDED. FRAME MATERIAL THICKNESS WAS 0.060.	AJS	08.08.11
E	INCORPORATED D1. D2253-1 WAS D2253 (NCR 533).	KE	05.11.10
D	MODIFIED LATCH, REDRAWN	KE	99.09.14
C	ADDED LATCH AND LABEL PLATE	BK	96.05.23
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2330	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET ASSEMBLY (206B)	NTS
DATE	09.02.05	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

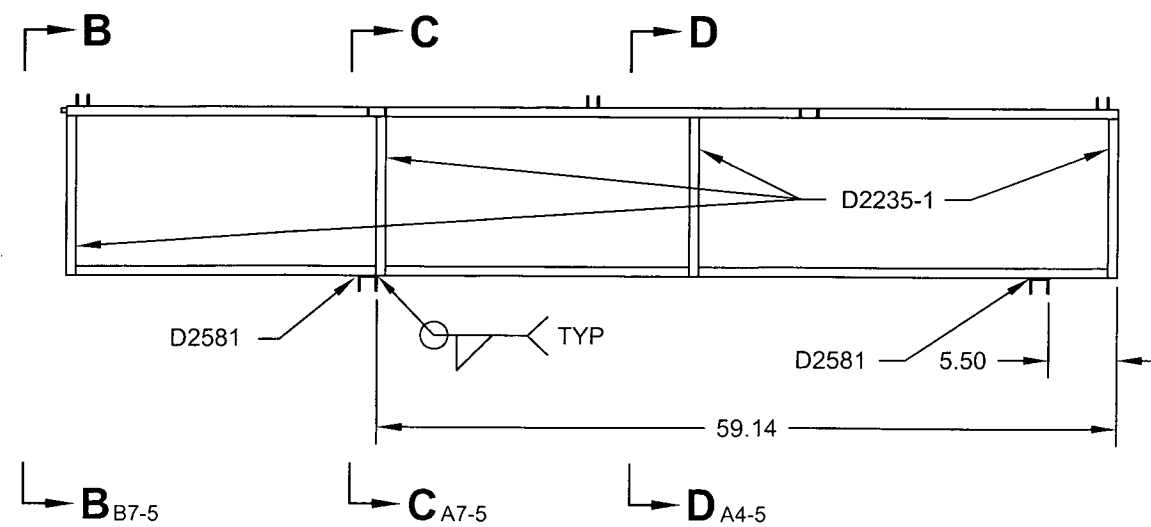
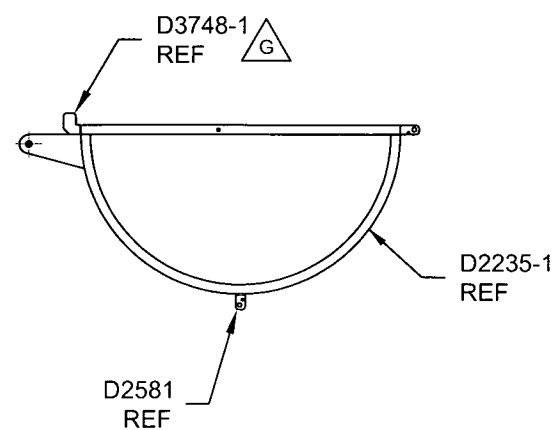
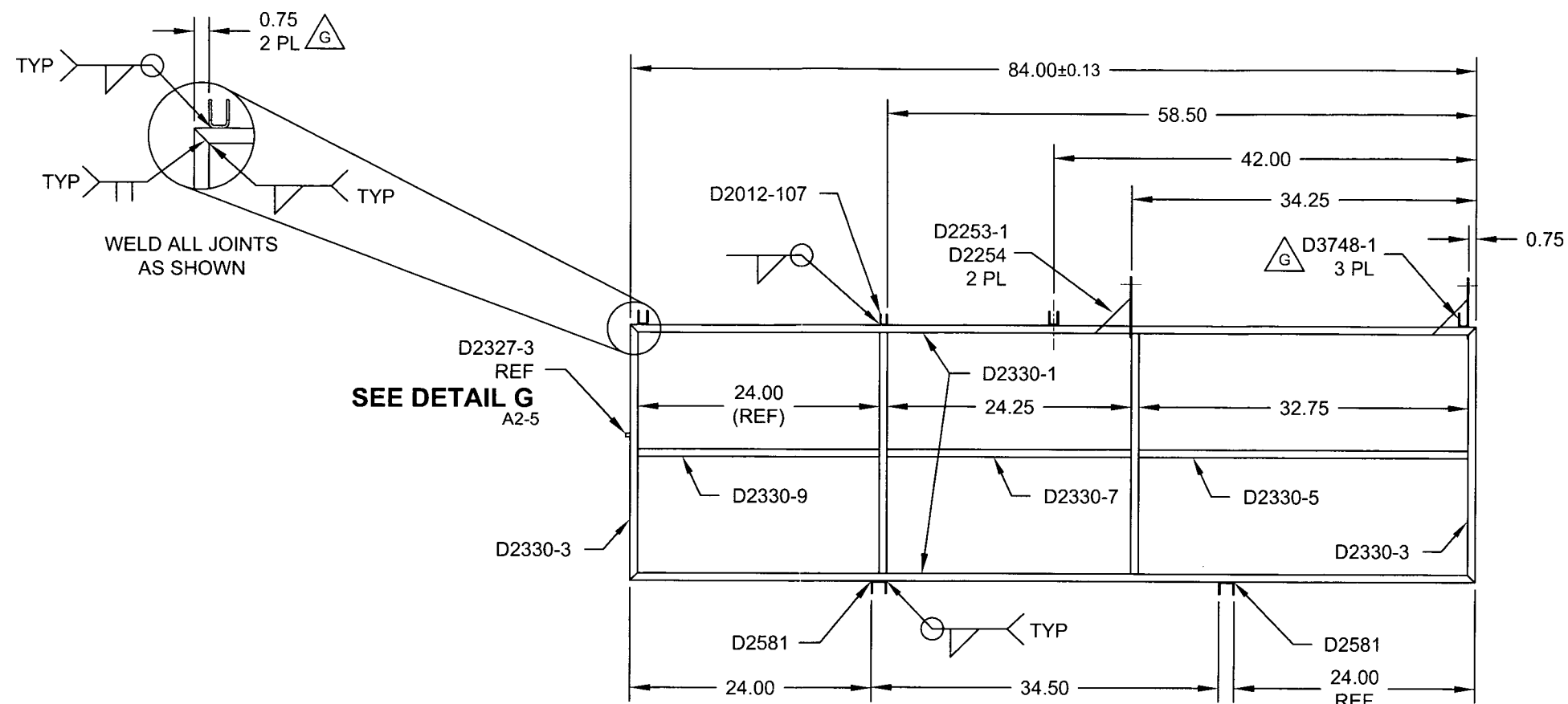


LID FRAME NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004
- 9) ALIGN WITH ADJACENT D2581 ON BASE
- 10) CENTER D3749-1 HINGE HALF ON D3748-1 HINGE HALF LOCATED ON D2330-011 BASKET BASE ASSEMBLY

D2330-043 LID FRAME

DESIGN	JB	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2330	SHEET 2 OF 6
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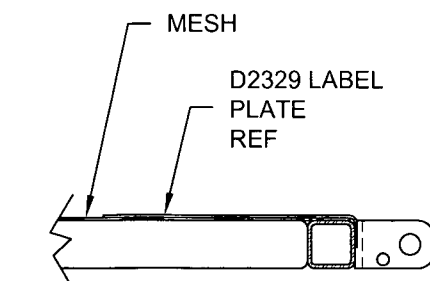
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09.02.06
FOR H&I 2009

BASE FRAME NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004

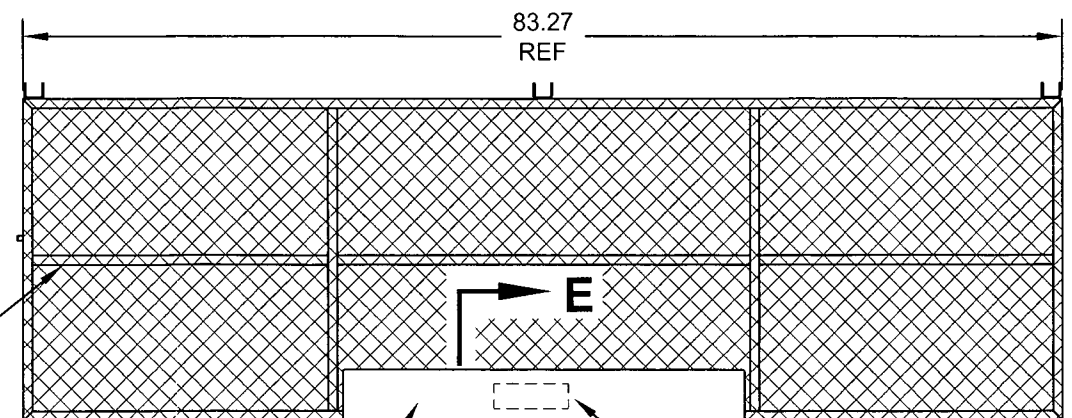
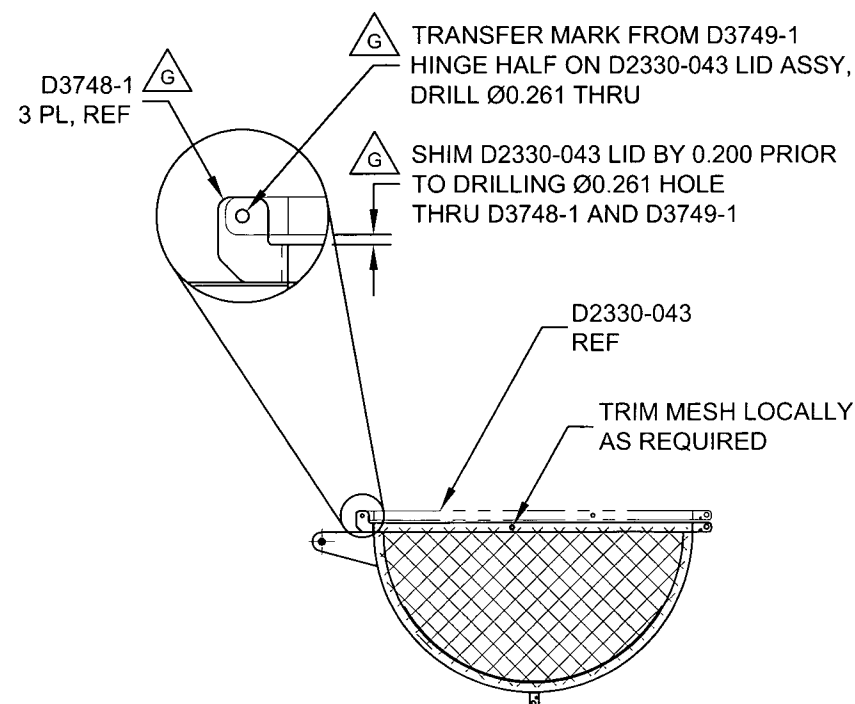
D2330-041 BASE FRAME ASSEMBLY

DESIGN	JB	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2330	SHEET 3 OF 6
APPROVED		TITLE	SCALE
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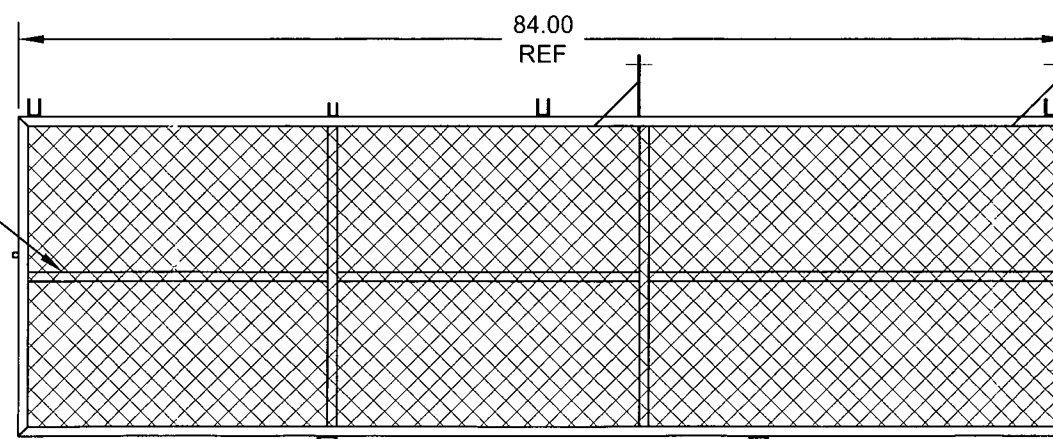


SECTION E-E C3-4
VIEW ROTATED 90° CCW

TACK WELD EACH
STRAND END OF
MESH TO FRAME



D2330-043 LID ASSEMBLY



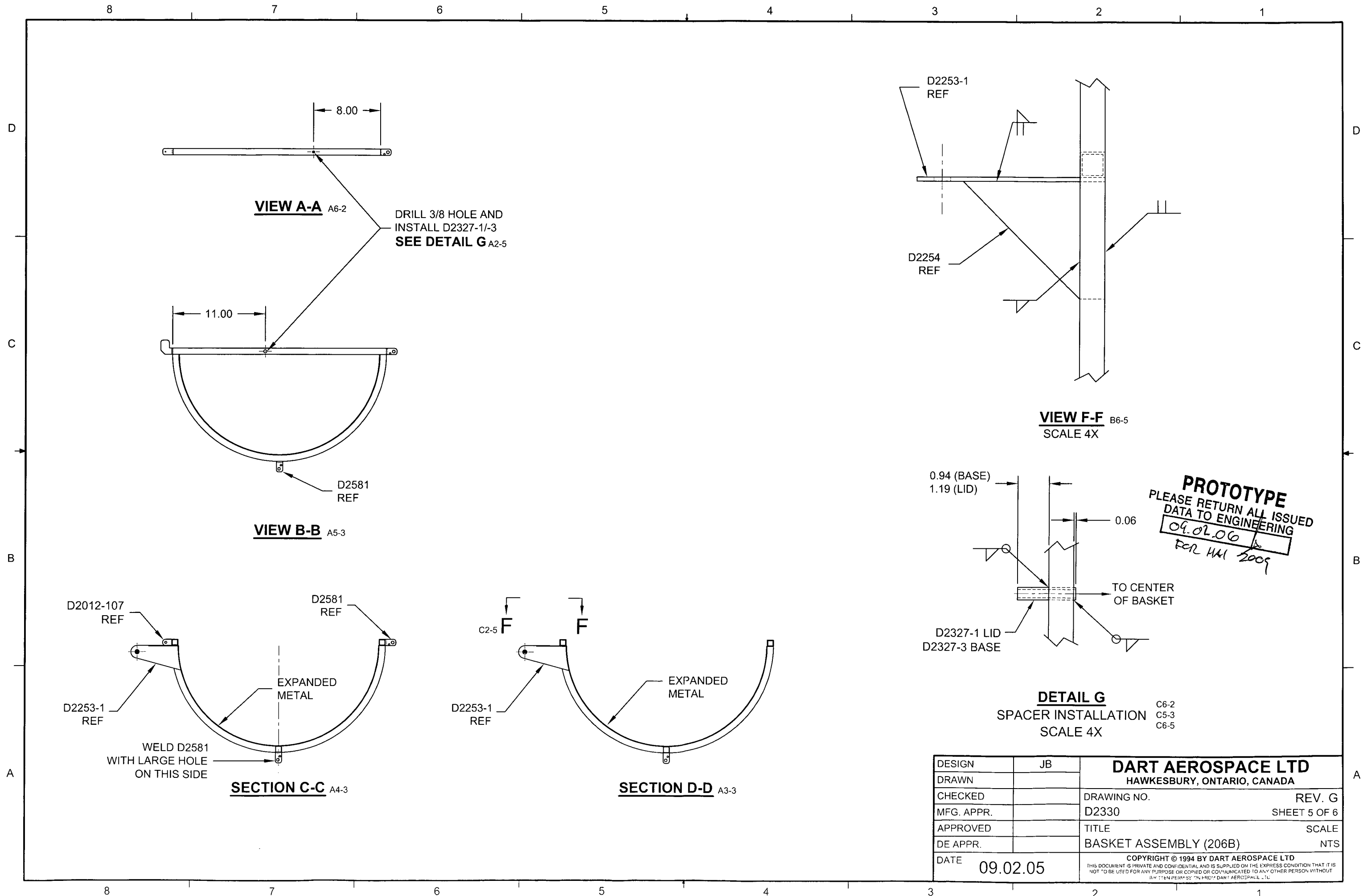
D2330-041 BASE ASSEMBLY

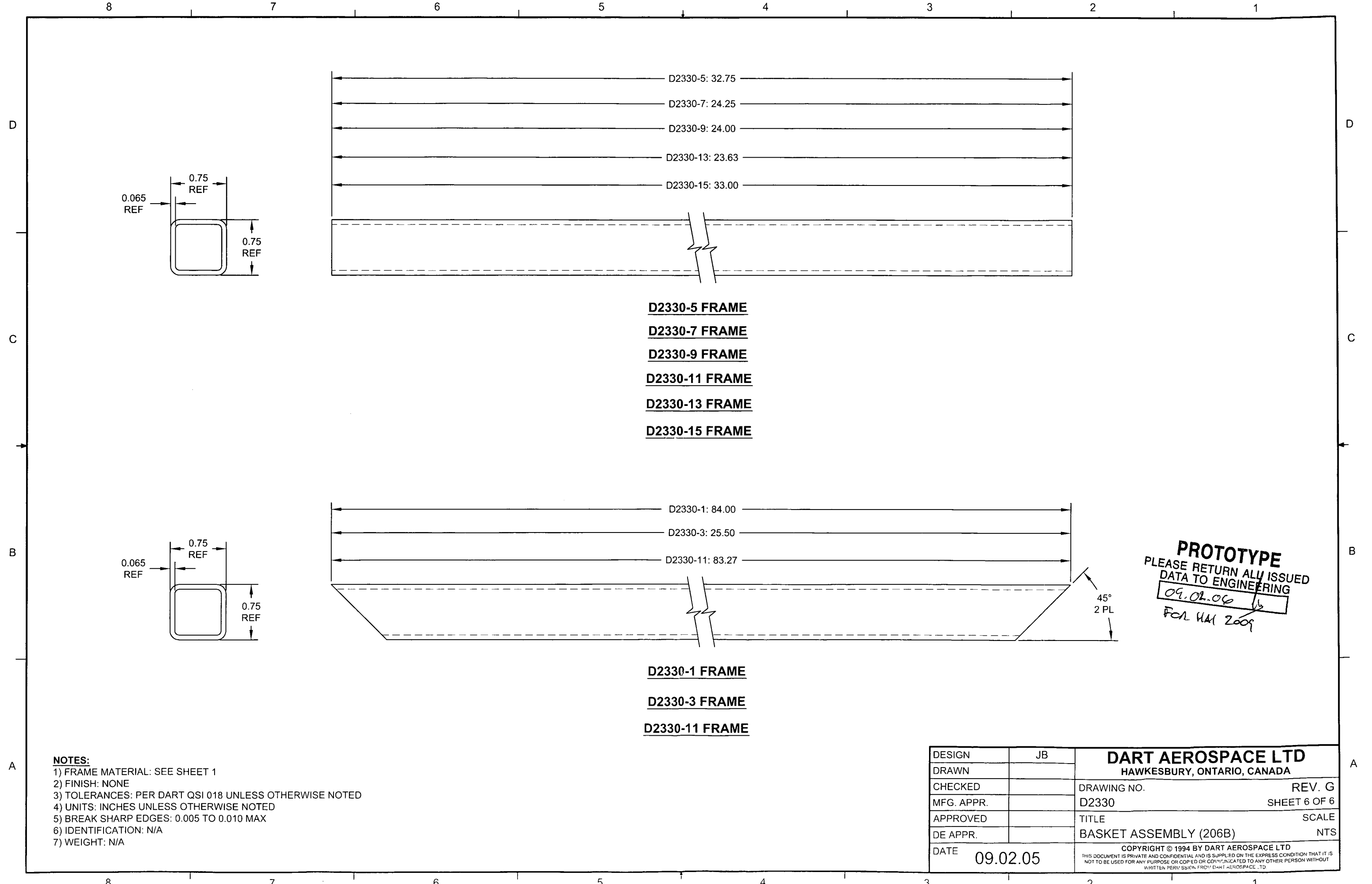
ASSEMBLY NOTES:

- 1) MATERIAL: SEE SHEET 1 FOR MESH MATERIAL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004

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FOR HAI 2009

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2330	SHEET 4 OF 6
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09.02.06
For HM 2009

- NOTES:**
- 1) FRAME MATERIAL: SEE SHEET 1
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2330	SHEET 6 OF 6
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